

Date: Monday, 5/26/2008 1:09:48 PM
 User: Chantal Lavoie

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: PANEL
Job Number	: 39495		
Estimate Number	: 13101		
P.O. Number	:	Part Number	: D36551
This Issue	: 5/26/2008 S.O. No. :	Drawing Number	: D3655 REVA
Prsht Rev.	: NC	Project Number	: 00204
First Issue	: / / Type : SMALL /MED FAB	Drawing Revision	: A
Previous Run	: 39492	Material	:
Written By	:	Due Date	: 5/30/2008 Qty: 4 Um: Each
Checked & Approved By	: <u>JMD 08.5.26</u>		
Comment	: Ext. Rev. A 07/12/13		
	Est Rev:B 08-03-06 prototype DD verified by:EC		
	Est Rev:C 08-04-07 revA DD verified by:EC		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	MLEXS093F600607	GE PLASTICS LEXAN SHEET
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Comment: Qty.: 3.7134 sf(s)/Unit Total : 14.8537 sf(s)

GE PLASTICS LEXAN SHEET

batch 105494 B 8-5-26

2.0	WATER JET	FLOW WATER JET
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Comment: FLOW WATER JET

1-Cut as per Dwg D3655

Dwg Rev: AProg Rev: AB 8-5-26

(4)

2-Deburr if necessary

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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B 8-5-26

Comment: INSPECT PARTS AS THEY COME OFF MACHINE

4.0	QC8	SECOND CHECK
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Comment: SECOND CHECK

G 08/05/26 (4)

5.0	PACKAGING 1	PACKAGING RESOURCE #1
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Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: 241AAS 08/05/27

(4)

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Monday, 5/26/2008 1:09:48 PM
User: Chantal Lavoie

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: PANEL

Job Number: 39495

Part Number: D36551

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC21

FINAL INSPECTION/W/O RELEASE



08/05/27 *[Signature]*

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



MF 08-05-27

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order:	39495
Description: Panel		Part Number:	D3655-1
Inspection Dwg: D3655 Rev: A		Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article
 ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
2.63	+/-0.030	2.63	X			
2.75	+/-0.030	2.74	X			
5.75	+/-0.030	5.75	X			
5.88	+/-0.030	5.88	X			
6.37	+/-0.030	6.37	X			
6.50	+/-0.030	6.50	X			
7.63	+/-0.030	7.62	X			
1.94	+/-0.030	1.945	X			
3.81	+/-0.030	3.805	X			
5.63	+/-0.030	5.635	X			
15.69	+/-0.030	15.69	X			
15.75	+/-0.030	15.75	X			
17.88	+/-0.030	17.88	X			
17.94	+/-0.030	17.94	X			
31.50	+/-0.030	31.50	X			
33.63	+/-0.030	33.63	X			
47.19	+/-0.030	47.19	X			
47.25	+/-0.030	47.25	X			
49.44	+/-0.030	49.44	X			
49.38	+/-0.030	49.375	X			
59.50	+/-0.030	59.50	X			
61.31	+/-0.030	61.31	X			
63.19	+/-0.030	63.19	X			
65.06	+/-0.030	65.06	X			
65.13	+/-0.030	65.13	X			
65.94	+/-0.030	65.94	X			
R9.50	+/-0.030	9.50	X			
R0.25	+/-0.030	.25	X			

Measured by:	RB	Audited by:	C	Prototype Approval:	N/A
Date:	8-5-21	Date:	08/05/21	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	08.04.17	New Issue	KJ/DD	

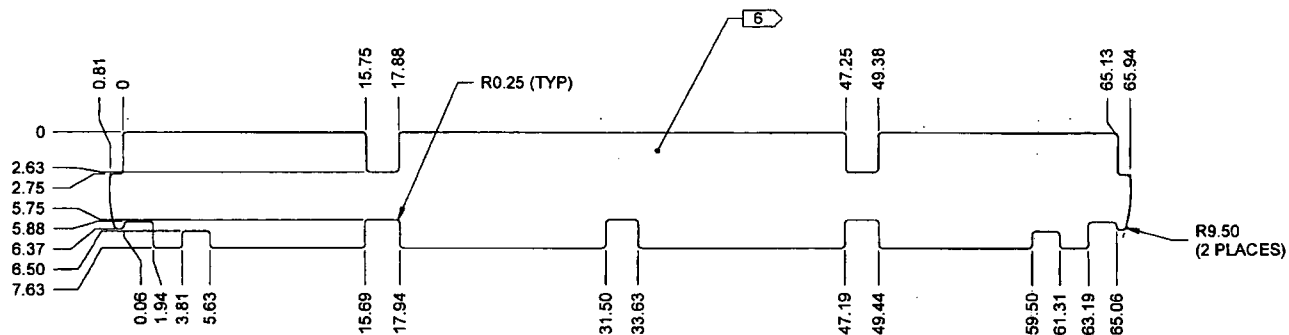
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



D3655-1 PANEL

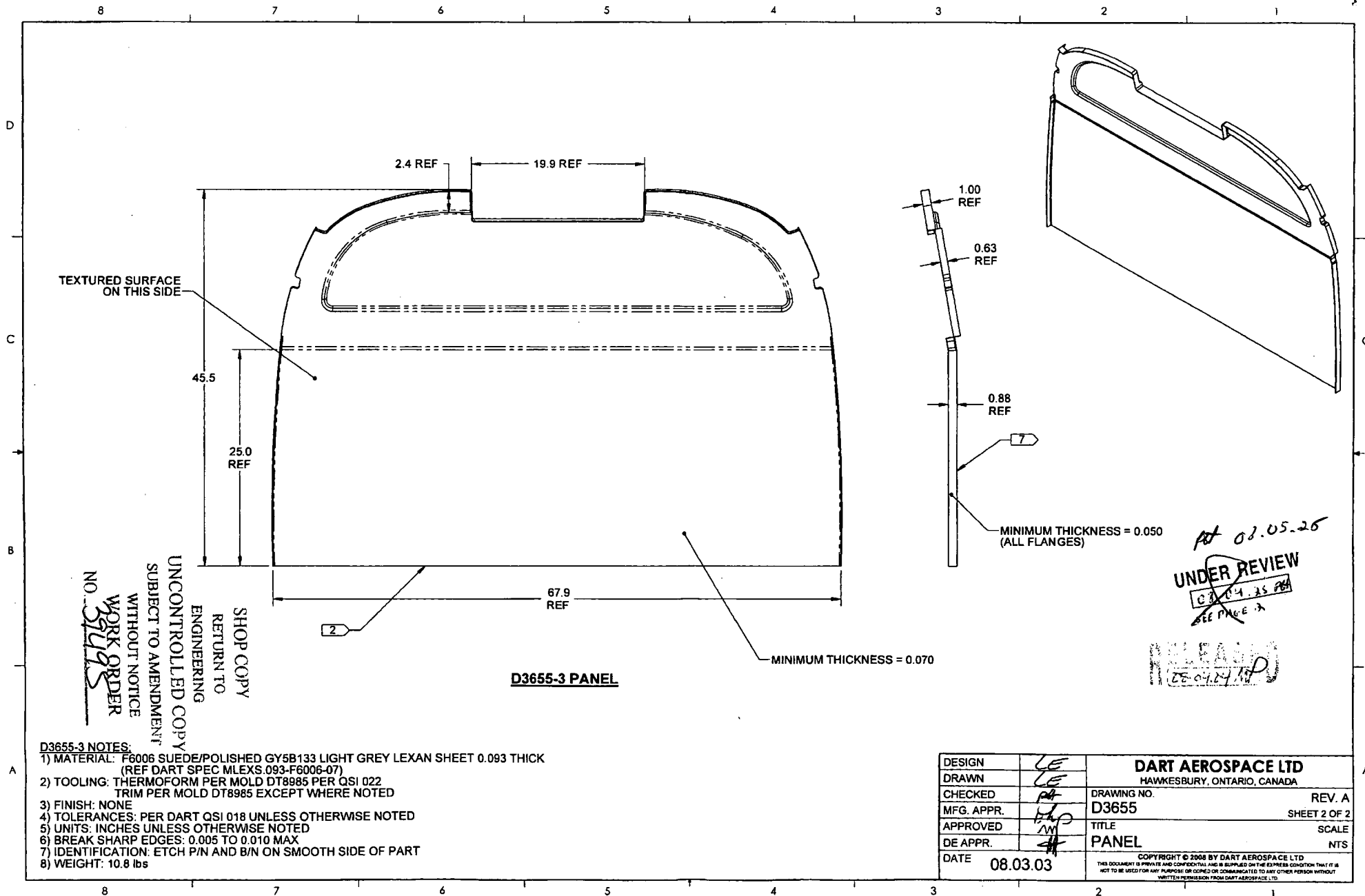
SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 31495

D3655-1 NOTES:

- 1) MATERIAL: F6006 SUEDE/POLISHED GY5B133 LIGHT GREY LEXAN SHEET 0.093 THICK
(REF DART SPEC MLEXS.093-F6006-07)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: ETCH P/N AND B/N ON SMOOTH SIDE OF PART
- 7) WEIGHT: 1.8 lbs

08.05.25
UNDER REVIEW
E3 1.25 PEA
SEE PAGE 3

A NEW ISSUE		LE	08.03.03
REV.	DESCRIPTION	BY	DATE
DESIGN	LE	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	LE		
CHECKED	LE	DRAWING NO.	REV. A
MFG. APPR.	MP	D3655	SHEET 1 OF 2
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DE APPR.	MP	PANEL	NTS
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